

Work Order ID 82566 - 1

April-03-12 8:35:20 AM

82566

ASAP

Page 1

Item ID: D2563

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 03/04/2012 Start Qty: 4.00

Required Date: 17/04/2012 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

QC:

Date: 12/04/03

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D2563	Rev C
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100	Large Fab	0.00
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100

Large Fab

Large Fab

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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110

QC

Quality Control

Memo

0.00

4 φ 12.05.02

12.05.02

12.05.04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Item ID: D2563

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Weldment Assembly

Start Date: 03/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

5/12/12

(4)

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

(4)

12-5-7

Hand Finishing

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

1 *φ*

12-05-09

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Weld per dwg A/R Aluminum rod Batch: 119185 0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remainig End cap as per Dwg D2563 using DT 8343

3-Grind

1 0

12.05.09

160

QC10- Inspect visual per QSI004- ground welds 0.00

160

QC

Memo

0.00

Quality Control

S 2105109

170

QC5- Inspect part completeness to step on W/O 0.00

170

QC

Memo

0.00

Quality Control

S 2105109

XC

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NS1

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NS2

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Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

175

Pressure Wash per QSI005 4.3

0.00

175


HandFinish

Memo

0.00

Hand Finishing

Touch up Alodine as per QSI005

IX  ML 12/05/09

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Memo

0.00

Powder Coating

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

IX  ML 12/05/09

MI21134

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
3200 F
11:30
121505

190

Wing Walk as per dwg QSI005 4.4 Batch

0.00

190

HandFinish

Memo

0.00

Hand Finishing

1  BL 12-5-9

W/O:		WORK ORDER CHANGES					
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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

1 x 4 11/05/09

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

Packaging

12/5/09

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/05/09
11/20/09

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 82566

82566

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116

Manufactured No

100

Each

95.5000

1

4

**

Ac 12.04.23

D2244-116

Step Extrusion

Location

Loc Qty

Loc Code

HALL

2.5

60307

2.5

WA

93

80803

93

D2561

Manufactured No

100

Each

38.0000

2

8

**

12.05.01

D2561

Lug

Location

Loc Qty

Loc Code

WA

24

80813

24

WA015

14

66813

5

74534

9

D2564

Manufactured No

100

Each

16.0000

2

8

**

12.05.01

D2564

Mounting Angle

Location

Loc Qty

Loc Code

WA018

16

B83712

71591

16

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

April-03-12 8:35:24 AM

Page 2

Work Order ID: 82566

82566

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

100

Each

50.0000

1

4

D2673-34

End Plate

**

12.05.01

Location

Loc Qty

Loc Code

WA

30

81468

30

WA015

20

59690

20

4

D2673-34

Manufactured No

150

Each

50.0000

1

4

D2673-34

End Plate

**

12.05.08

Location

Loc Qty

Loc Code

WA

30

81468

30

WA015

20

59690

20

4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

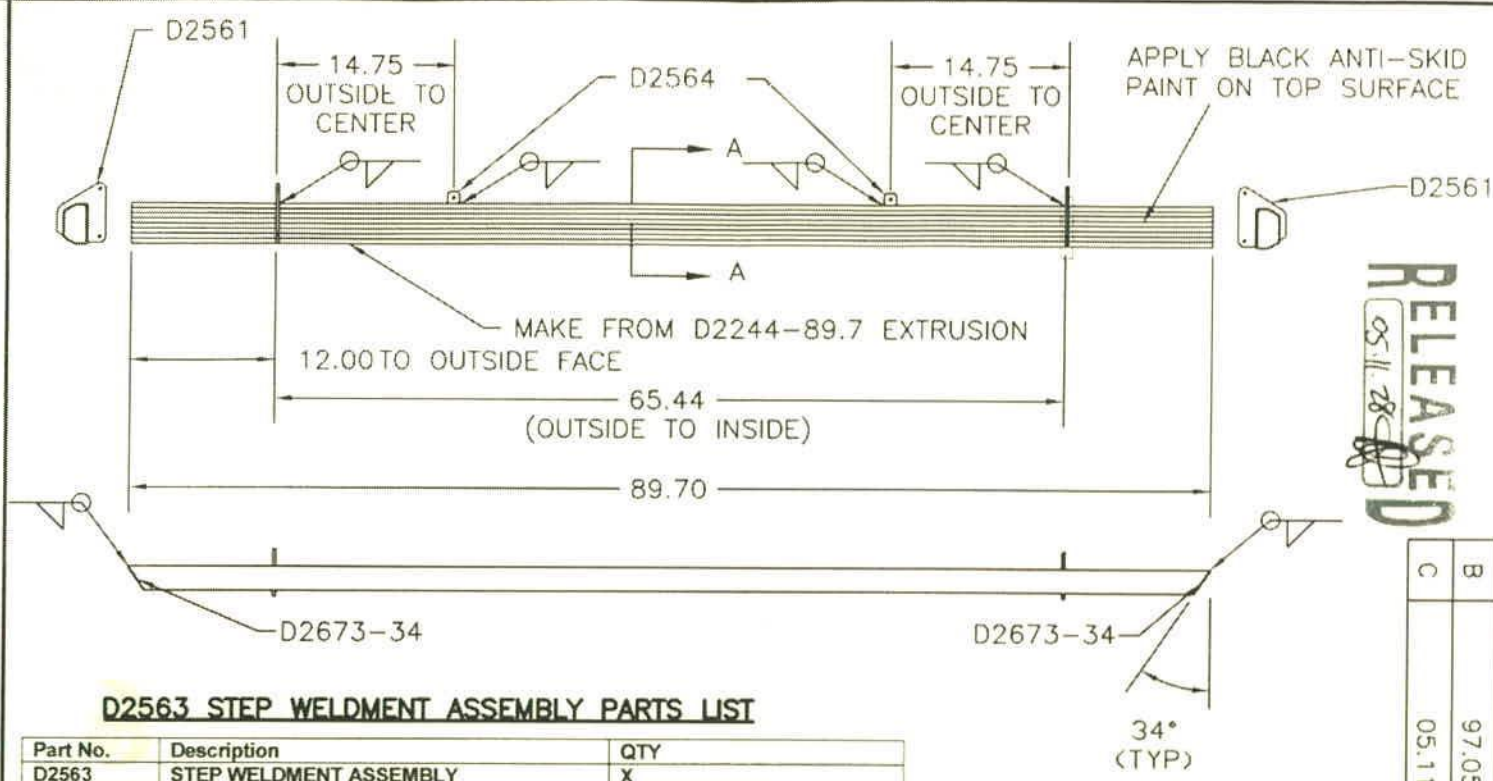
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

RELEASED
05-11-28

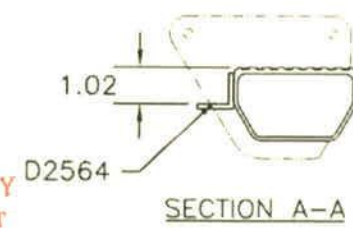


D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82566 MLJ
12/04/03



D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	PH	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2563
DATE	05.11.14			TITLE STEP WELDMENT ASSEMBLY
	A	96.04.26		NEW ISSUE
	B	97.05.14		END CAPS CHANGED (WAS D2248)
	C	05.11.14		UPDATE NOTES
				SCALE 1:15
				SHEET 1 OF 1
				REV. C

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